

Date: Tuesday, 3/11/2008 9:58:19 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services Drawing Name: FORWARD CAP
Job Number: 37768
Estimate Number: 10501
P.O. Number:
This Issue: 3/11/2008 S.O. No.:
Prsht Rev.: NC Part Number: D2744
First Issue: 1/1 Type: SMALL /MED FAB Drawing Number: D2744 REV C
Previous Run: 33996 Drawing Revision: C
Material:
Due Date: 4/10/2008 Qty: 30 Um: Each
Written By:
Checked & Approved By: 9/08 03 11
Comment: Est C 03.01.17 Reformat; Dwg revised KJ/RF
Est Rev:D Now on Waterjet 06-06-16 JLM
Est Rev:E As per Rev C 07-07-28 JLM Verified By:

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M5052H32S080 5052-H32 .080 Sheet



Comment: Qty.: 0.1914 sf(s)/Unit Total: 5.7425 sf(s)
Material: 5052-H32 (QQ-A-250/8) or 6061-T6 (QQ-A-250/11) 0.080 thick.
Use off-cuts
M5052H32S.080) Batch 100947X16 B 8-3-20

100742X

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D2744
Dwg Rev: C
Prog Rev: C

B 8-3-20

(42)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 8-3-20

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

10603-24 (43)
counted

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 5745

28/3/24 (43)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PD Date: 08/03/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



43

Comment: FINAL INSPECTION/W/O RELEASE

208/03/25

Job Completion



u 08-03-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

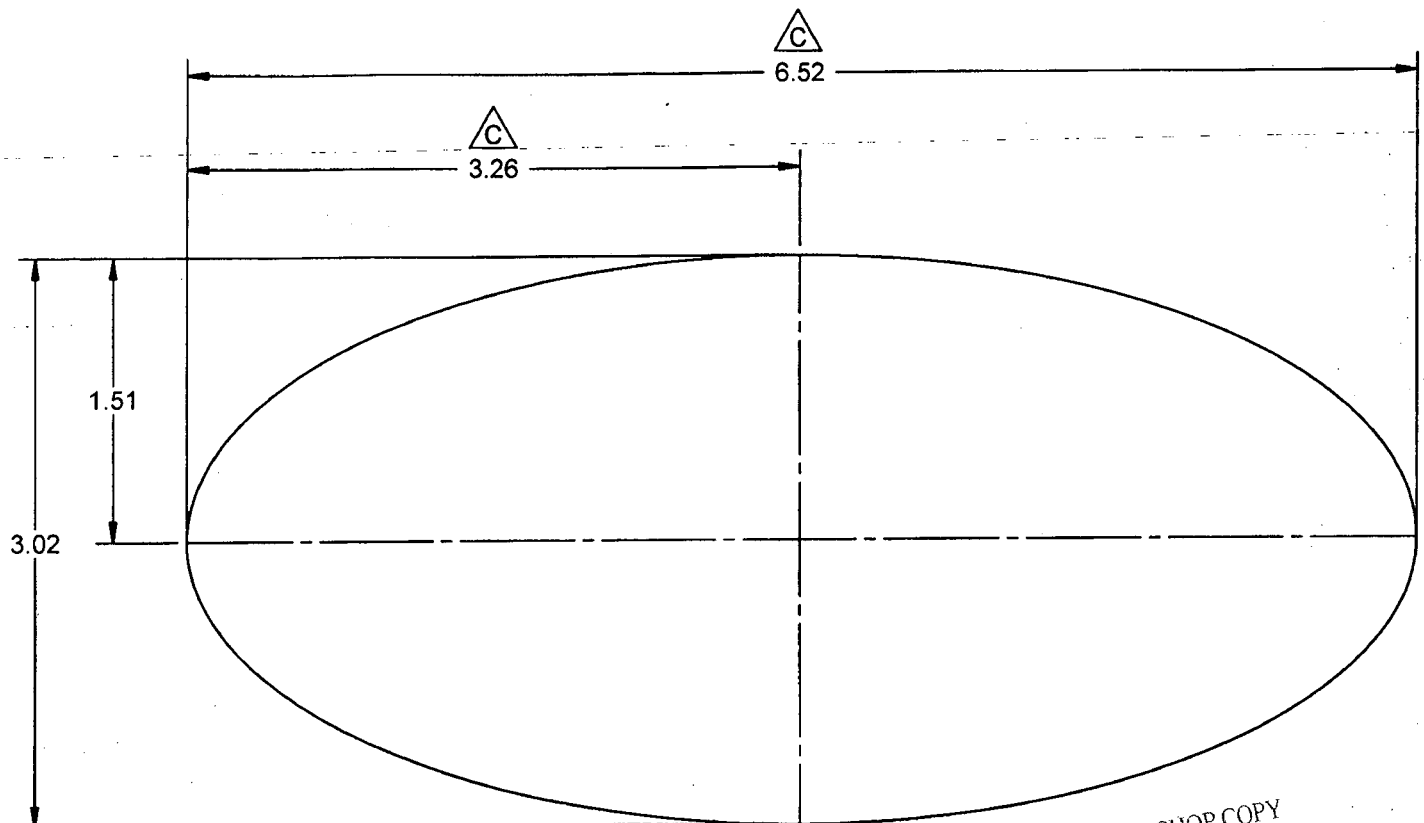
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D2744	REV. C SHEET 1 OF 1
DATE 06.10.05		TITLE CAP	SCALE 1:1
REV	DATE	DESCRIPTION	
A	98.04.16	NEW ISSUE	
B	02.12.18	RE-DESIGN	
C	06.10.05	3.26 WAS 3.13; 6.52 WAS 6.27	

RELEASED
07-08-02 #**D2744 CAP**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **37768**

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6 SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.080)
OR ALUMINUM 5052-H32 SHEET 0.080 THICK PER QQ-A-250/8 OR AMS 4016
(REF DART SPEC M5052H32S.080)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS

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